

Amendments to the Specification:

Please amend the Specification as follows:

On page 5, please delete the paragraph beginning at line 27, and insert in its place the following paragraph:

-- FIGURES 4 and 5 are enlarged, front and rear isometric views, respectively, of the opposing-force support assembly 160 of the manufacturing assembly 100 of FIGURE 1. In this embodiment, the opposing-force support assembly 160 includes a clamp-up actuator 162 having a clamp-up pin 164 that is engageable with the workpiece 102. A first (or y-axis) actuator 166 is coupled to the clamp-up actuator 162 and to a first baseplate 168, and is extendible along the y-axis. The first baseplate 168 is slideably coupled to a pair of first auxiliary rails 170 mounted on a second baseplate 172. Similarly, the second baseplate ~~172~~ 170 is slideably coupled to second auxiliary rails 174 mounted on the x-axis carriage 122. As best shown in FIGURE 5, the first auxiliary rails 170 are approximately parallel with the x-axis, and the second auxiliary rails 174 are approximately parallel with the z-axis. A second (or x-axis) actuator 176 is coupled between the first baseplate 168 and the second baseplate 172, and is extendible along the x-axis. A third (or z-axis) actuator 178 is coupled between the second baseplate 172 and to the x-axis carriage 122, and is extendible along the z-axis. The first, second, and third actuators 166, 176, 178 may be operatively coupled to the controller 134. Thus, the first, second, and third actuators 166, 176, 178 may be used to controllably position the clamp-up pin 164 of the opposing-force support assembly 160 at a desired location along the y-axis, the x-axis, and the z-axis, respectively. --

On page 6, please delete the paragraph beginning at line 16, and insert in its place the following paragraph:

-- In operation, the manufacturing assembly 100 may be mounted onto the workpiece 102 and vacuum may be provided to the vacuum assemblies 114, thereby securing the track assembly 110 in a desired position. A hole 103 may be formed in the workpiece 102 in any desired manner, such as during fabrication of the workpiece 102, or using the tool assembly 150 or another drilling device. Next, the clamp-up pin 164 may be positioned in the hole 103. The positioning of the clamp-up pin 164 into the hole 103 may be accomplished in a variety of ways. For example, the position of the clamp-up pin 164 along the x-axis may be accomplished by controllably positioning the x-axis carriage 122 using the first drive motor 130, or controllably positioning the first baseplate 168 along the first auxiliary rails 170 using the second actuator 176, or by a combination of both of these methods. Similarly, the position of the clamp-up pin 164 along the y-axis may be accomplished by controllably positioning the y-axis carriage 124 using the second drive motor 140, or by controllably actuating the first actuator 166, or both. Finally, the position of the clamp-up pin 164 along the z-axis may be accomplished by controllably positioning the second baseplate 172 along the second auxiliary rails ~~174~~ 170 using the third actuator 178. In one particular embodiment, the x-axis and y-axis carriages 122, 124 are employed to perform coarse, relatively large scale positioning, and the second and first actuators 176, 166 are used to provide finer, relatively small scale positioning of the clamp-up pin 164 along the x- and y-axes, respectively. --